

Date: Wednesday, 11/22/2006 1:39:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29647B
 Estimate Number : 10462
 P.O. Number : *N/A*
 This Issue : 11/22/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL / MED FAB
 Previous Run : 29236B
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 061122
 Comment : Est: A 04.04.19 New issue KJ/JLM

Drawing Name : SUPPORT

Part Number : D32782
 Drawing Number : D3278 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 11/29/2006

Qty: *20* Um: *Split* Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X02000

6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: *M19295**mk 07/01/08**(52)*

2.0

SHEAR *SAW*

SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

*mk 07/01/08**(52)*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

*J.F. 07/01/10**(20)*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/01/10**(20)*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 07.01.10**20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



07-01-10 *JS/M* (20)



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



M7102391



(20x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R/YL 07/01/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/01/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

ml 07/01/11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

ml 07/01/11

Job Completion



u 07-01-11

DART AEROSPACE LTD		Work Order:	29647B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.100"	✓			
0.359	+/-0.005	.359"	✓			
0.615	+/-0.010	.615"	✓			
0.250	+/-0.010	.249"	✓			
1.480	+/-0.005	1.485"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.120"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.982"	✓			
R0.130	+/-0.010	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø.261"	✓			
R0.375	+/-0.010	R.375"	✓			
0.875	+/-0.010	.877"	✓			
0.500	+/-0.010	.500"	✓			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.722"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.125	+/-0.010	.128"	✓			

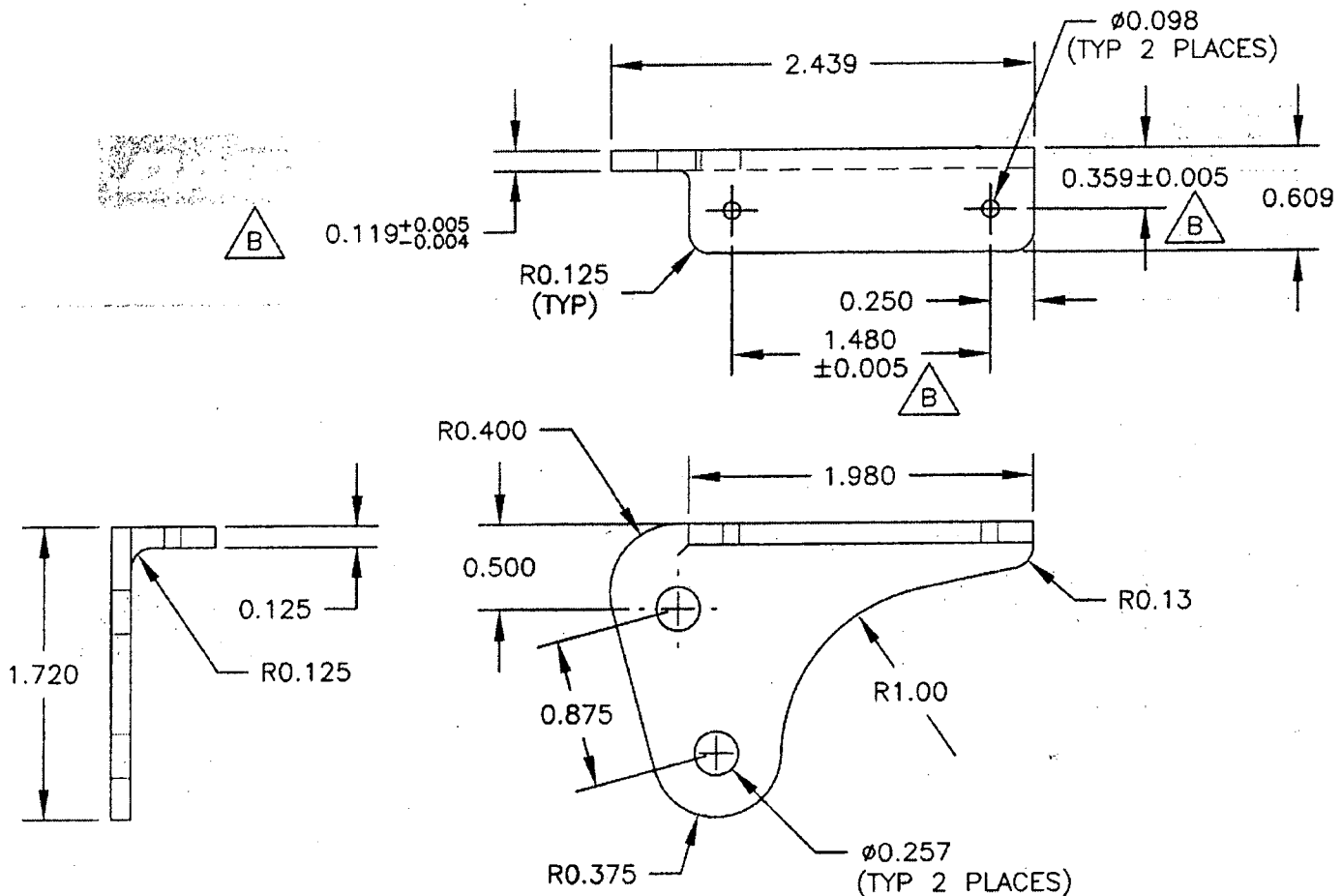
Measured by: J.F.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/01/09	Date: 07/01/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	[Signature]

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

WORK COPY
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29647B

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